

Date: Thursday, 25/09/2008 3:25:01 PM  
 User: Melanie Fauteux

## Process Sheet

|                       |  |                  |                              |
|-----------------------|--|------------------|------------------------------|
| Customer              | : CU-DAR001 Dart Helicopters Services            | Drawing Name     | : HANDLE AND LOCK- DOWN ASSY |
| Job Number            | : 42286  |                  |                              |
| Estimate Number       | : 13446  |                  |                              |
| P.O. Number           | :  | Part Number      | : D3451041                   |
| This Issue            | : 25/09/2008 S.O. No. :                          | Drawing Number   | : D3451 REVA                 |
| Prsht Rev.            | : NC   | Project Number   | : N/A                        |
| First Issue           | : 11 Type : LARGE FAB ASSY                       | Drawing Revision | : A                          |
| Previous Run          | : 41076  | Material         | :                            |
| Written By            | :  | Due Date         | : 02/10/2008                 |
| Checked & Approved By | : <u>MF 08-09-25</u>                             | Qty:             | 2 Um: Each                   |
| Comment               | : Est Rev:A 08-06-27 new issue DD verified by:ec |                  |                              |

## Additional Product

Job Number:



|         |                       |               |
|---------|-----------------------|---------------|
| Seq. #: | Machine Or Operation: | Description : |
|---------|-----------------------|---------------|

|     |        |                 |
|-----|--------|-----------------|
| 1.0 | D34511 | Tube Handle Arm |
|-----|--------|-----------------|



Comment: Qty.: 2.0000 Each(s)/Unit Total: 8.0000 Each(s)

Tube Handle Arm

batch: B39955x1 D42615 x3

MF 08-10-17

|     |       |               |
|-----|-------|---------------|
| 2.0 | GP211 | Rubber Handle |
|-----|-------|---------------|



Comment: Qty.: 2.0000 Each(s)/Unit Total: 8.0000 Each(s)

Rubber Handle

batch: m108992

MF 08-10-17

|     |              |             |
|-----|--------------|-------------|
| 3.0 | PB6743001103 | Tube Handle |
|-----|--------------|-------------|



Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)

Tube Handle

batch: B41364

MF 08-10-17

|     |             |                              |
|-----|-------------|------------------------------|
| 4.0 | LARGE FAB 1 | LARGE FABRICATION RESOURCE 1 |
|-----|-------------|------------------------------|



Comment: LARGE FABRICATION RESOURCE 1

1- weld as per dwg PB67-43001

SP 08.10.16

(2x)

|     |     |                           |
|-----|-----|---------------------------|
| 5.0 | QC9 | VISUAL WELDING INSPECTION |
|-----|-----|---------------------------|



Comment: VISUAL WELDING INSPECTION

LPL 08.10.17

BF 08-10-17

(2x)

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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HANDLE AND LOCK- DOWN ASSY

Job Number: 42286

Part Number: D3451041

Job Number:



Seq. #: Machine Or Operation: Description :

6.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

508/10/17 42

7.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

M-F 08/10/17

(2X)

8.0 POWDER COATING POWDER COATING



Comment: POWDER COATING

Powder Coat Green Sandtex (Ref: 4.3.5.8) as per QSI 005 4.3

M 102316

(2X)

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

3:15  
320°F  
3:45

M-F 08/10/17

9.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

CP 08/10/20 (2)

10.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1- assemble rubber handle as per dwg PB67-43001

CP 08/10/20 (2)

11.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

508/10/20 (2)

12.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 512

8/10/20

(2X)

13.0 QC21 FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/10/21

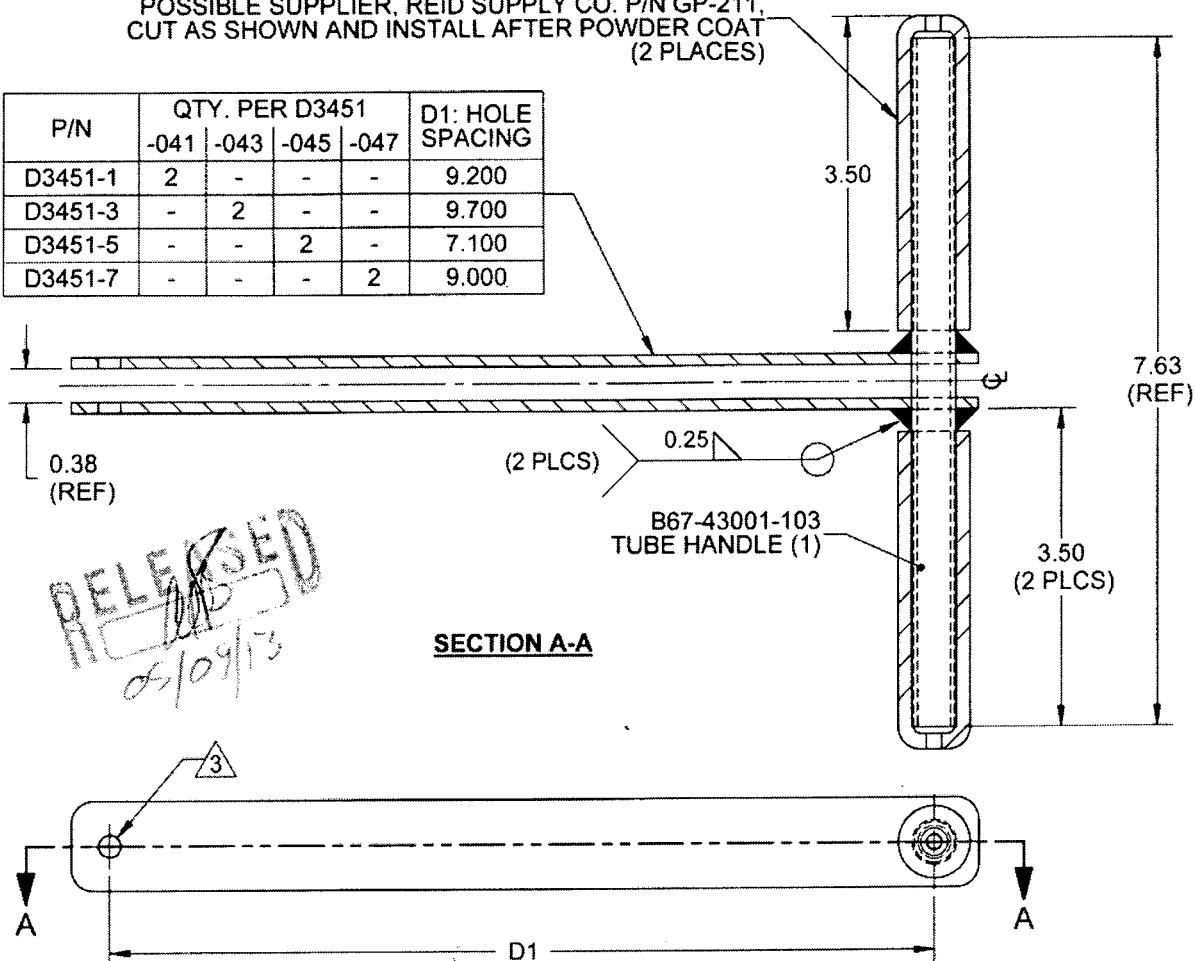
MF 08-10-21



|                               |                                |  |                        |
|-------------------------------|--------------------------------|--|------------------------|
| DESIGN<br><i>[Signature]</i>  | DRAWN BY<br><i>[Signature]</i> | <b>DART AEROSPACE LTD</b><br>HAWKESBURY, ONTARIO, CANADA |                        |
| CHECKED<br><i>[Signature]</i> | APPROVED<br><i>[Signature]</i> | DRAWING NO.<br><b>D3451</b>                              | REV. A<br>SHEET 1 OF 2 |
| DATE<br><b>05.08.25</b>       |                                | TITLE<br><b>HANDLE &amp; LOCK-DOWN ASS'Y</b>             | SCALE<br>1:2           |
| A                             | 05.08.25                       | NEW ISSUE  |                        |

0.50" ID x 4.875" LONG BLACK VINYL HANDLE,  
POSSIBLE SUPPLIER, REID SUPPLY CO. P/N GP-211,  
CUT AS SHOWN AND INSTALL AFTER POWDER COAT  
(2 PLACES)

| P/N     | QTY. PER D3451 |      |      |      | D1: HOLE<br>SPACING |
|---------|----------------|------|------|------|---------------------|
|         | -041           | -043 | -045 | -047 |                     |
| D3451-1 | 2              | -    | -    | -    | 9.200               |
| D3451-3 | -              | 2    | -    | -    | 9.700               |
| D3451-5 | -              | -    | 2    | -    | 7.100               |
| D3451-7 | -              | -    | -    | 2    | 9.000               |



**D3451-041/-043/-045/-047 HANDLE & LOCK-DOWN ASS'Y**

**D3451-041 SUPERSEDES PREMIER P/N B67-43001-41**

**D3451-045 SUPERSEDES PREMIER P/N B67-43001-39**

**D3451-047 SUPERSEDES PREMIER P/N B67-43001-55**

**NOTES:**

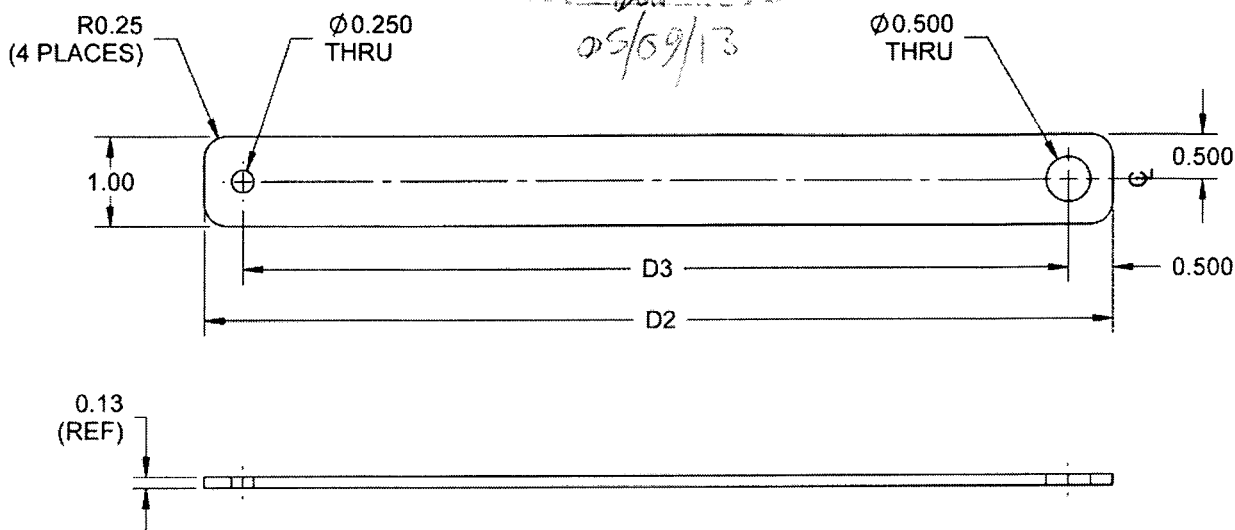
- 1) WELD PER DART QSI 004
- 2) CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) MASK BEFORE PAINTING.
- 4) FINISH: POWDER COAT PAINT GREEN SANDTEX (4.3.5.8) PER DART QSI 005 4.3
- 5) PART IS SYMMETRICAL ABOUT CENTER LINE.
- 6) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 7) ALL DIMENSIONS ARE IN INCHES
- 8) BREAK ALL SHARP EDGES 0.005 TO 0.010

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|                               |                                |  |                        |
|-------------------------------|--------------------------------|--|------------------------|
| DESIGN<br><i>[Signature]</i>  | DRAWN BY<br><i>[Signature]</i> | <b>DART AEROSPACE LTD</b><br>HAWKESBURY, ONTARIO, CANADA |                        |
| CHECKED<br><i>[Signature]</i> | APPROVED<br><i>[Signature]</i> | DRAWING NO.<br><b>D3451</b>                              | REV. A<br>SHEET 2 OF 2 |
| DATE<br><b>05.08.25</b>       |                                | TITLE<br><b>HANDLE &amp; LOCK-DOWN ASS'Y</b>             | SCALE<br>1:2           |



| P/N     | D2: CUT LENGHT | D3: HOLE SPACING |
|---------|----------------|------------------|
| D3451-1 | 10.25          | 9.200            |
| D3451-3 | 10.63          | 9.700            |
| D3451-5 | 8.00           | 7.100            |
| D3451-7 | 10.00          | 9.000            |

#### **D3451-1/-3/-5/-7 TUBE HANDLE ARMS**

**D3451-1 SUPERSEDES PREMIER P/N B67-43001-303**

**D3451-5 SUPERSEDES PREMIER P/N B67-43001-301**

**D3451-7 SUPERSEDES PREMIER P/N B67-43001-101**

#### **NOTES:**

- 1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) BAR  
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR  
PER AMS-QQ-A-200/8 (OR AMS 4160)  
(REF. DART SPEC. M6061T6B0.125)
- 2) PART IS SYMETRICAL ABOUT CENTER LINE.
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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*42286*